

Work Order ID 83130

Friday, April 13, 2012 10:08:39 AM

Rush

83130

Page 1

Item ID: D3084-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Strut
 Start Date: 4/13/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 4/25/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3084	C

100 0.00
100 BAND SAW
 Small Fab Memo 0.00
 Small Fab 1- Punch per Dwg. D3084 and spec control dwg D2638
 2-Deburr

110 0.00
110 QC5- Inspect part completeness to step on W/O
 QC Memo 0.00
 Quality Control

120 0.00
120 Weld per dwg A/R Aluminum rod Batch: *M120854*
 Large Fab Memo 0.00
 Large Fab 1- Weld ends per dwg.
 2- Grind flush .

SP 12/05/09

(4)

(x4)

(4)

EL 12-5-9.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00		8/2/05/09					
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		8/2/05/09		(20)			
150 *150* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 Memo START TIME: 3:50 OVEN TEMPERATURE: 320°F FINISH TIME: 4:20	0.00 0.00				4X			M-L 12/05/09

M117338

W/O:		WORK ORDER CHANGES					
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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: <u>27R</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

H ϕ BL 12-5-10
 12/5/10
 ME 12-0540

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Page 1

Friday, April 13, 2012 10:08:43 AM

Work Order ID: 83130

83130

Parent Item: D3084-3

D3084-3

Parent Item Name: Strut

Start Date: 4/13/2012

Required Date: 4/25/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A new issue DD 10.04.26 verified by:EC
10.10.13 AS PER DWG REV.C DD verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6T0.750W.058

Purchased

No

100

f

152.9500

2.4833

10.456

M6061T6T0 750W 058

**

6061-T6 RD Tube .750 x.058W

5/26/09

Location

Loc Qty

Loc Code

MAT015

152.95

10099

24

112652

128.95

12

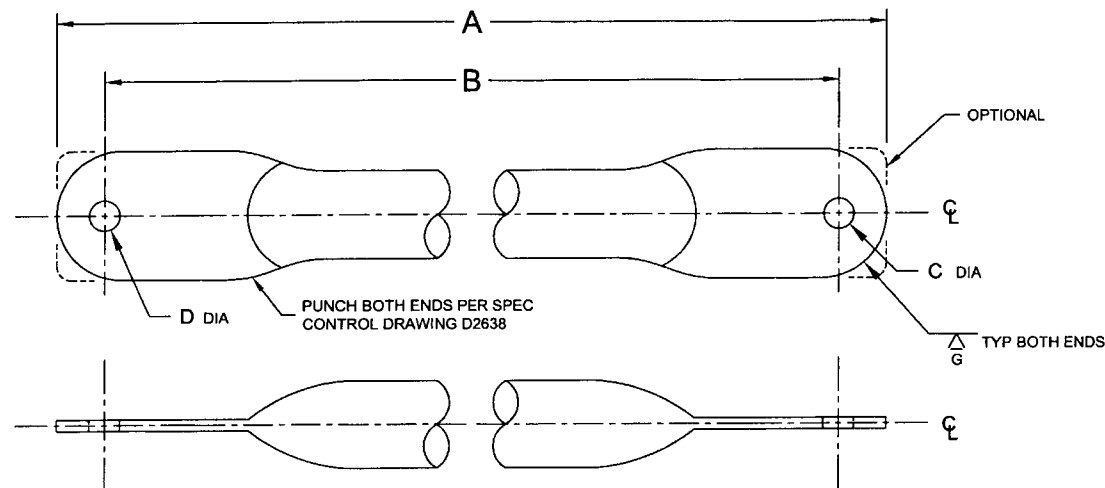
Dart Aerospace Ltd

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	A	B	C	D	WEIGHT	FINISH
D3084-1	37.18	36.38	0.257	0.323	0.46 lbs	WHITE POWDER COAT (4.3.5.1) PER DART QSI 4.3
D3084-3	29.80	29.00	0.257	0.257	0.37 lbs	GREY POWDER COAT (4.3.5.6) PER DART QSI 4.3

D3084-XX STRUT
MAKE FROM DT3084-XX
(XX IS THE RESPECTIVE DASH NUMBER)

RELEASED
2010-10-13

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 SEAMLESS TUBING
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8
REF DART SPEC M6061T6T0.750W.058
- 2) FINISH: SEE TABLE FOR POWDER COAT COLOR
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: NONE.
- 7) WEIGHT: SEE TABLE
- 8) WELD PER DART QSI 004.



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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 83130

C	RMV CHEM CONV (NCR 10-059, ZN A6-1)	CP	10.05.18
B	DRAWING REFORMAT. -3 ADDED. NOTES UPDATED	JPH	10.04.13
A	NEW ISSUE	CP	02.01.21
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. C
CHECKED		D3084	SHEET 1 OF 1
MFG. APPR.		TITLE	SCALE
APPROVED		STRUT	NTS
DE APPR.		COPYRIGHT © 2002 BY DART AEROSPACE LTD	
DATE	10.05.18	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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